

Date: Wednesday, 06/08/2008 9:20:52 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TURNING DETAIL FOR D2891-1
Job Number	: 41004		
Estimate Number	: 13232		
P.O. Number	:	Part Number	: DSK076
This Issue	: 06/08/2008 S.O. No. :	Drawing Number	: DSK076 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 39065	Material	:
Written By	:	Due Date	: 13/08/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JLD 08.8.06</u>		
Comment	: est rev A. 08.03.13 new issue EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6104003

Round Billet, 17-4



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Billet

Batch: B 39625RD 08/08/04

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI LATHE

Turn blank for as per Folio FA046

RD 08/08/24

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RD 08/08/24

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

RD 08/08/25

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: ENCRD 08/08/25(10)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/25

Job Completion

u 08.08.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41004
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.279	2.279	2.279	2.279	2.279
B	3.702	3.722		3.712	3.711	3.711	3.712	3.712
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
I	0.913	0.933		.928	.928	.928	.928	.928
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.100	.100	.100	.100	.100
L								
M								
N								
O								
P								

Measured by: <i>JD</i>	Date: 08/08/25
Audited by: <i>SD</i>	Date: 08/08/25
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

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J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.100	.100	.100	.100	.100
L								
M								
N								
O								
P								

Measured by: RD	Date: 08/08/24
Audited by: LF	Date: 08/08/20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

Dart Aerospace Ltd

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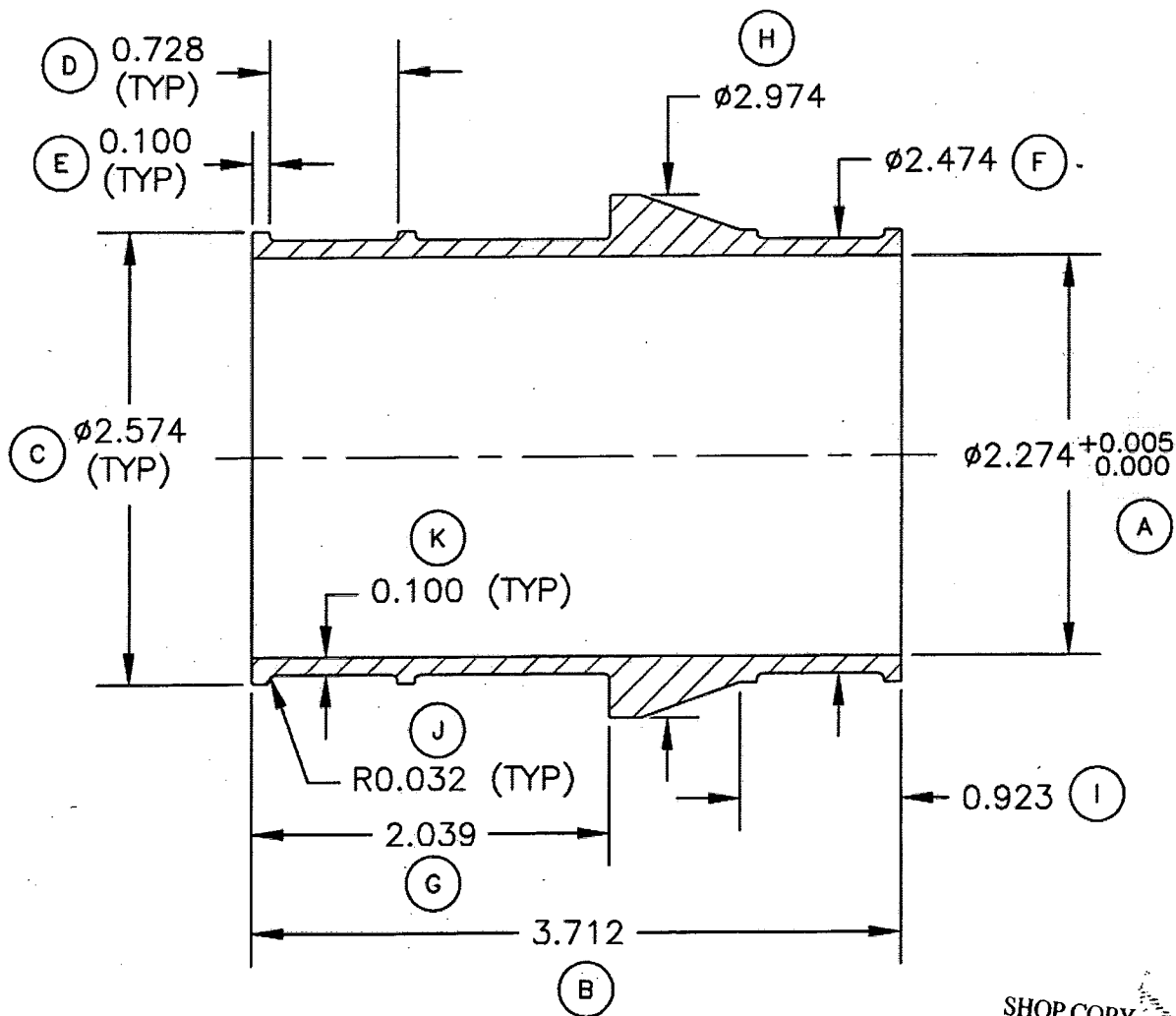
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DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CH	APPROVED CH	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
8.07.01 CHD2891-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41004

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